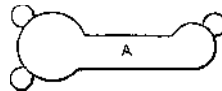


and dowel pins, as indicated in the engraving, but sometimes this V-block may also be made adjustable, in order to take up the variations of the pieces placed in it, and also in order to act as a clamp. A V-block of this character is shown in Fig. 5. In this, *A* is the adjustable V-block, having an oblong



O

C

Fig. i. Locating  
Pads  
in Jigs

Ffig. 2. Pins  
used for  
Locating Work

hole *B* to allow for the adjustment. The block is held down in place by a collar-head screw *C*, which passes through the elongated hole. The under side of the block is provided with a tongue *D*, which enters into a slot in the jig body itself, the V-block being thereby prevented from turning sideways. The

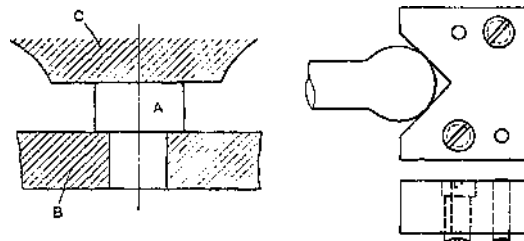


Fig. 3. Inserted Pin  
used Fig. 4. V-block  
for Locating  
for Locating and  
Support- Round  
Work or Cylindrical  
ing Work  
Surfaces

screw *E* passes through the

wall of the jig, or through some lug, and prevents the V-block from sliding back when the work is inserted into the jig. It is also used for adjusting the V-block and, in some cases, for clamping the work. The V-blocks are usually made of machine steel, but when larger sizes are needed they may be made of cast iron. Little is gained, however,